

Date: Thursday, 11/24/2005 12:15:06 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BEARPAW KIT (19"X24")
Job Number : 24965	
Estimate Number : 10323	
P.O. Number : N/A	Part Number : K10008
This Issue : 11/24/2005 S.O. No. : N/A	Drawing Number : D2432 REV F3
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : F3
Previous Run : N/A	Material : N/A
Written By : See comment below	Due Date : 12/10/2005 Qty: 10 Um: Each
Checked & Approved By : See comment below	
Comment : Est Rev:J 04.02.17 Blank size changed KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile:

K10008

D206-559-013

D350-578-011

D315-670-011

D427-659-011

and create labels per PPP K10008

CHG006(Bag Bluefiles separately)

DH 05/11/30 (10)

2.0	MUHMWB10	UHMW 1" Black
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**Comment:** Qty.: 3.4116 sf(s)/Unit Total : 68.2311 sf(s)

blank: 19.500" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5

Material: Black UHMW 1"

(MUHMWB10)

Batch: M 19055

05/11/26

10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2432 Identify as D2432F

3-Deburr

05/11/28 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/24/2005 12:15:07 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X24")

Job Number: 24965

Part Number: K10008

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

EN 05128 128

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 65.11.30

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B050

Rubber Cushion



Comment: Qty.: 6.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2182B050

Rubber Cushion

B23172

8.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total : 240.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274

Radius Block

B24066

64 mcy

B 24872 x56

2 D2432F(ref only)

Bearpaw

B24965

9.0

D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2438

Clamp

B23175 16 mcy

B 23818

42 mcy

B21586 2 mcy

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Seq. #:

Machine Or Operation:

Description :

10.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 240.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2529 Washer B23177

11.0

D2732050

Rubber Cushion



Comment: Qty.: 6.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2732-050 Rubber Cushion B24182

12.0

AN415A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 240.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-15A Bolt M17566

13.0

AN417A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 240.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-17A Bolt M15432

14.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 480.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 AN960JD416 Washer M18136

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Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 240.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4

Nut (or -4)

M17997

05/11/30

10

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

05/12/09

10

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPK10008

Location: _____

REV E

05/12/09

10

18.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

500 05/12/13 (10)

05/12/12

05/12/12

Job Completion



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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

F1	99.03.03	ADD	DEO 9143
F2	01.03.28	Ø0.93 WAS Ø0.75	RF
F3	02-01-23	CLARIFY BORE DIMS	RF

RELEASED
98.06.17 KB

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N

EFFECTIVE DEOS
9143

D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

F1	99.03.03	ADD DEC 9143
F2	01.03.28	$\phi 0.93$ WAS $\phi 0.75$ RF
F3	02-01-23	CLARIFY CORR DIMS RF

RELEASED
93.06.17 K8

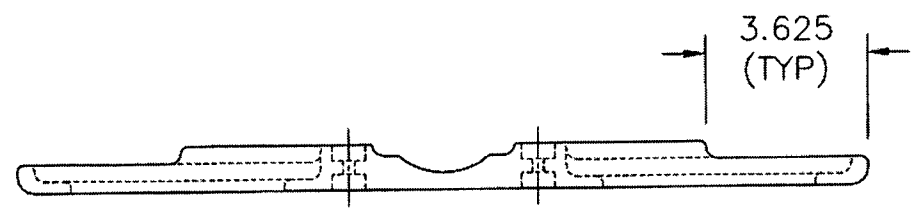
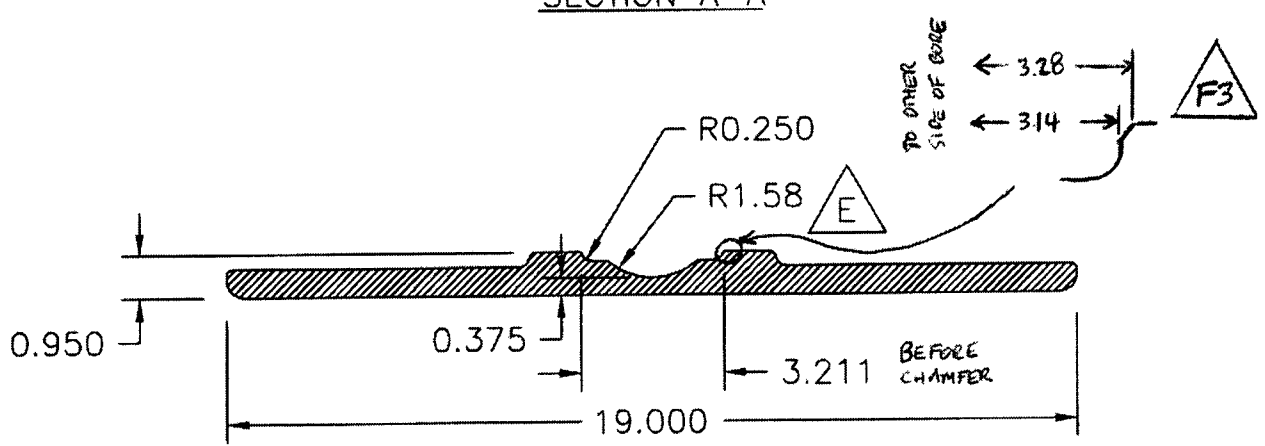
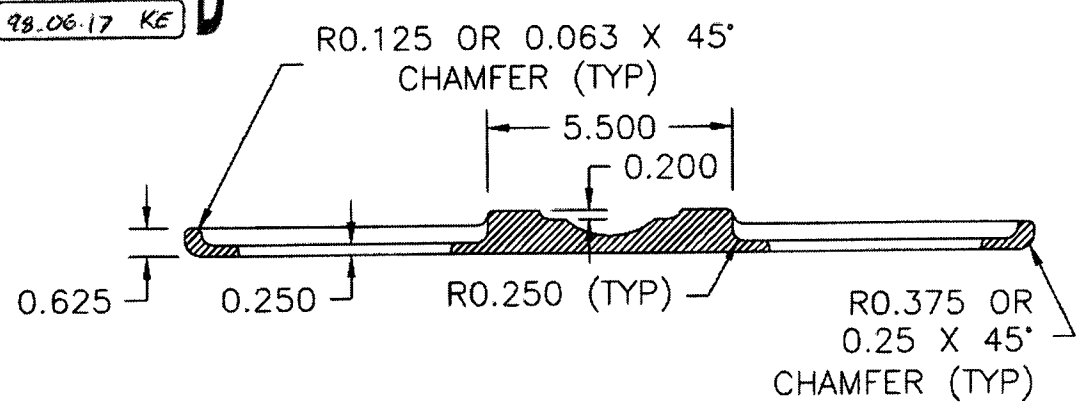
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURT, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2432	REV. F SHEET 1 OF 2
DATE 98.05.12	<i>MD</i>	TITLE BEARPAW	SCALE 1:6
A	95.10.31	NEW ISSUE	
B	96.01.24	RE-DESIGN	
C	96.03.26	CHANGE BORE AND C'BORE DEPTH	
D	96.06.04	MOVE SLOT	
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS	
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N	



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

RELEASED
98.06.17 KE



DART AEROSPACE LTD		Work Order: 24965
Description: Bearpaw		Part Number: D 2432
Inspection Dwg: D2432	Rev: F3	1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	ts
A	0.063 x 45°	+0.030/-0.010	0.063 x 45°	—		
B	5.500	+/-0.030	5.500	—		
C	0.200	+/-0.030	0.203	—		
D	0.25 x 45°	+/-0.030	0.25 x 45°	—		
E	R0.250	+/-0.030	0.250	—		
F	0.250	+/-0.010	0.260	—		
G	0.625	+/-0.030	0.633	—		
H	0.375	+/-0.010	0.376	—		
I	0.950	+0.030/0.010	0.966	—		
J	19.000	+/-0.030	19.000	—		
K	3.14	+/-0.030	3.14	—		
L	3.28	+/-0.030	3.28	—		
M	Ø0.260	+0.005/-0.000	0.260	—		
N	Ø0.93	+/-0.030	0.926	—		
O	0.30	+0.030/-0.000	0.302	—		
P	23.750	+/-0.030	23.750	—		
Q	7.375	+/-0.030	7.380	—		
R	4.250	+/-0.010	4.251	—		
S	2.000	+/-0.030	2.002	—		
T	9.000	+/-0.010	9.001	—		
U	9.000	+/-0.010	9.001	—		
V	0.375	+/-0.010	0.380	—		

Measured by: EN	Audited by: JL	Prototype Approval:
Date: 05/11/27	Date: 05/11/27	Date:

Rev	Date	Change	Revised KJ/RF	Approved
A	04.01.09	New Issue		

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